Date: User: Tuesday, 21/10/2008 2:46:06 PM

Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 42778

Estimate Number

: 10503

P.O. Number This Issue

First Issue

Comment

: 21/10/2008

Prsht Rev.

: NC

: 41114

: 11

Type

S.O. No. :

Part Number

Drawing Number

Drawing Name

: D2745

: BUSHING

D2745 REV B : N/A

Project Number Drawing Revision

Material

Due Date : 15/11/2008



Each

Written By

Previous Run

Checked & Approved By

Update to turn in house NG : Est C 02.03.07

Est Rev:D 07-10-23 Removed tumbling

: MACHINED PARTS

JLM Verified

By:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M303R0750

303 Round Bar 0.750

Comment: Qty.:

0.1007 f(s)/Unit Total:

20.1390 f(s)

303 ROUND .75"

Machine per Folio FA201 Material: AISI 303 SS

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2515

2-Deburr

QC2 3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK





Comment: SECOND CHECK **PACKAGING 1**

PACKAGING RESOURCE #1

700X

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 26

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:		Date:	
								_ Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:		`	WORK ORDI	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			ion B	Verification		Approval	Approval
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector
							ŧ		
					.				

NOTE: Date & initial all entries

Date: User: Tuesday, 21/10/2008 2:46:06 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 42778

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

Comment: FINAL IN

FINAL INSPECTION/W/O RELEASE

08/10/27 g

Job Completion



ION/W/O RELEASE

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHA	NGES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	:	PAR #:	Fault Cate	egory:	NCR	Yes	No DQ	A:	Date:	
			•			QA: N	C Close	d:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFOR	RMANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section			<u> </u>	Verific	cation	Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Descripti	on	Sign & Date	Secti	on C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	 Work Order:	42728
Description: Bushing	Part Number:	D2745
Inspection Dwg: D2745 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.060	+/-0.010	-060	/				
0.400	+/-0.010	. 399					
0.060	+/-0.010	.055					
1.020	+/-0.010	1022		<u></u>			
0.030 x 20°	+/-0.010	0.030×200					
Ø0.472	+/-0.010	0,472					
Ø0.375	+0.006/-0.001	0.375					
Ø0.560	+/-0.010	9.560		<u> </u>			
Ø0.750	+/-0.010	0.745					
			:				
			,	-		,	

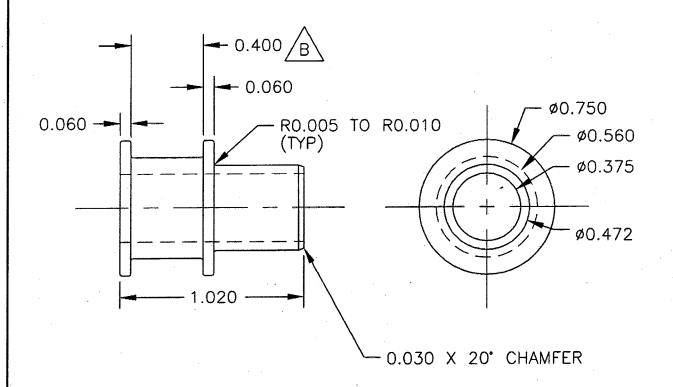
Measured by:	Audited by: And	Prototype Approval:	N/A
Date: 06/1024	Date: 08/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
В	07.11.26	Tolerance for Ø0.375 revised	KJ/EC/DD	- XZ



DESIGN	DRAWN BY	DART AEROSPACE U	
CHECKED	APPROVED	DRAWING NO.	REV. B
M	IKE	D2745	SHEET 1 OF 1
DATE	· /	TITLE	SCALE
98.10.23		BUSHING	2:1
A	98.04.16	NEW ISSUE	
В	98.10.23	DIM 0.400 WAS 0.380	

PELEASED PS DS



MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 RETU

ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK-ORDER